

Work Order ID 52928

October 19, 2009 10:58:25 AM

Page 1

Item ID: D3815-3

Accept

Revision ID: A

Item Name: Web

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 16.00

Required Date: 11/02/09 Req'd Qty: 16.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-10-19

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3815

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3815 ☐ Dwg Rev: ☒ Prog

Rev: ☒ 2-Deburr if necessary

2524
.663

13 9-11-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

13 9-11-5

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2524 08/10/06

47

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Page 2

Item ID: D3815-3

Accept

Revision ID: A

Item Name: Web

Start Date: 10/19/09 Start Qty: 16.00

Required Date: 11/02/09 Req'd Qty: 16.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

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Page 3

Item ID: D3815-3

Accept

Revision ID: A

Item Name: Web

Start Date: 10/19/09 Start Qty: 16.00

Required Date: 11/02/09 Req'd Qty: 16.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/11
mt
09-11-11

Picklist Print

October 19, 2009 10:58:29 AM

Page 1

Work Order ID: 52928

Parent Item: D3815-3RevA

Parent Item Name: Web

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	45.0396	8.3032	9.1		



2024-T3 .063 sheet

LB 9-11-5

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

45.03962419

102942

1.5

105916

3.69

106223

1.47

109463

0.00947368

110980

5.4854

111787

30.8847505

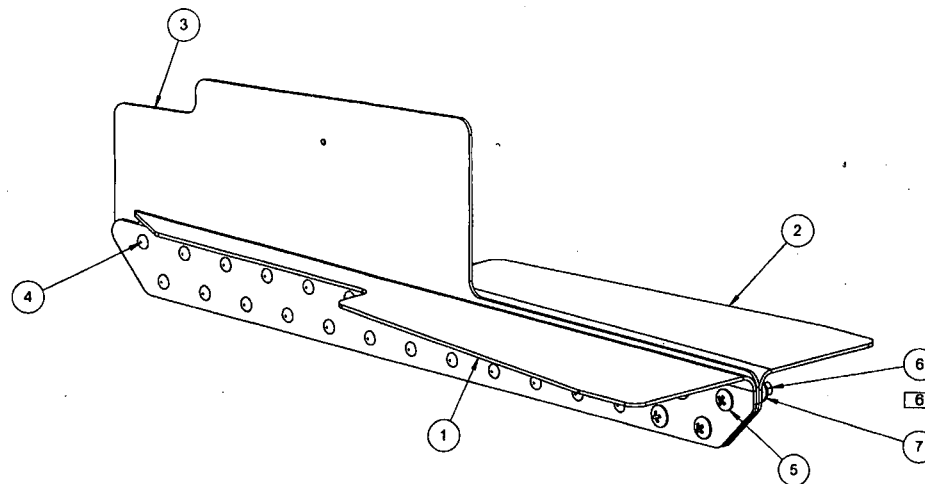
19059

2

$$105916 \times 5 = 2.6$$

$$109463 \times 2 = 1.5$$

$$111787 \times 10 = 6$$



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WORK ORDER
NO. 5292F
B10910-19

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

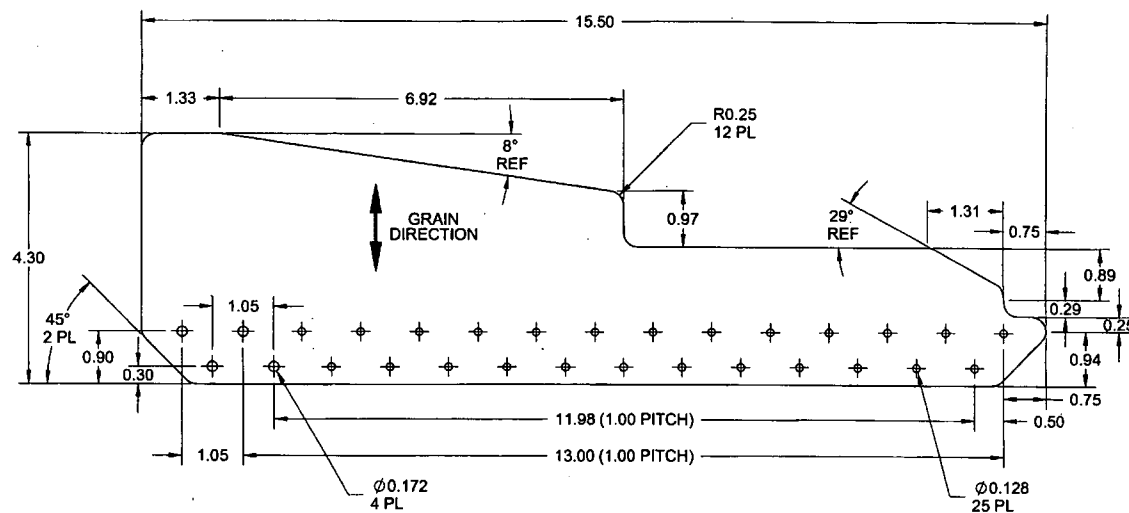
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NOTES:

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

A		NEW ISSUE		08.09.22	
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
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WORK ORDER NO. 3925



D3815-1F FLAT PATTERN

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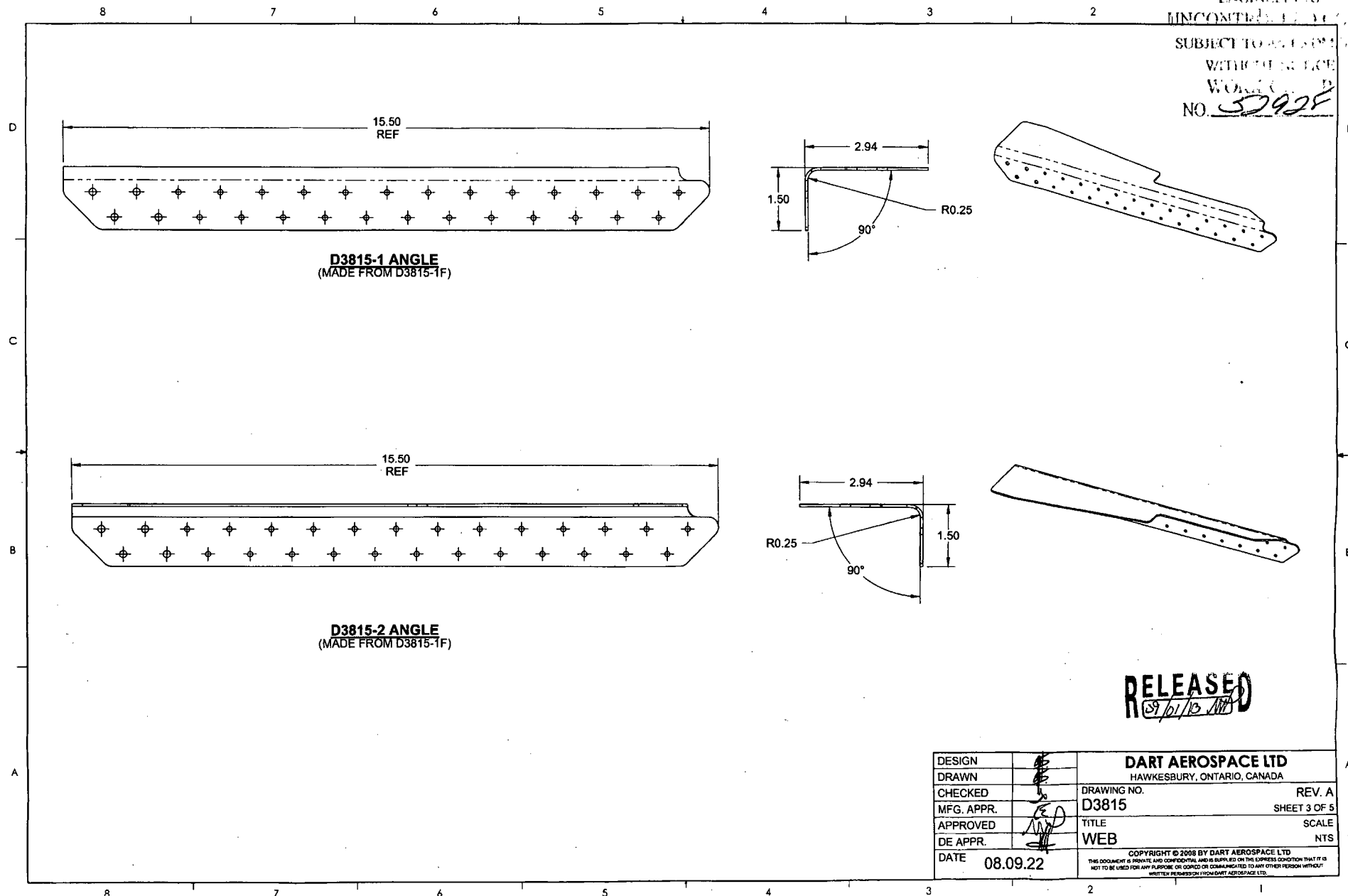
- NOTES:
- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES 0.005 TO 0.010
 - 4) IDENTIFICATION: N/A
 - 5) WEIGHT: 0.29 lbs

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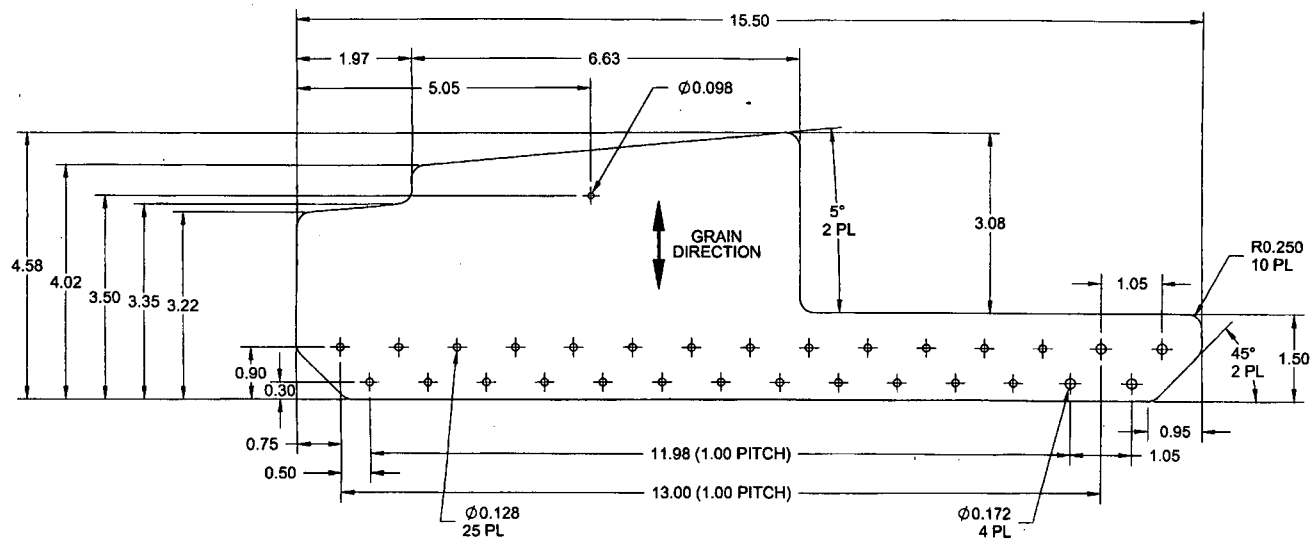
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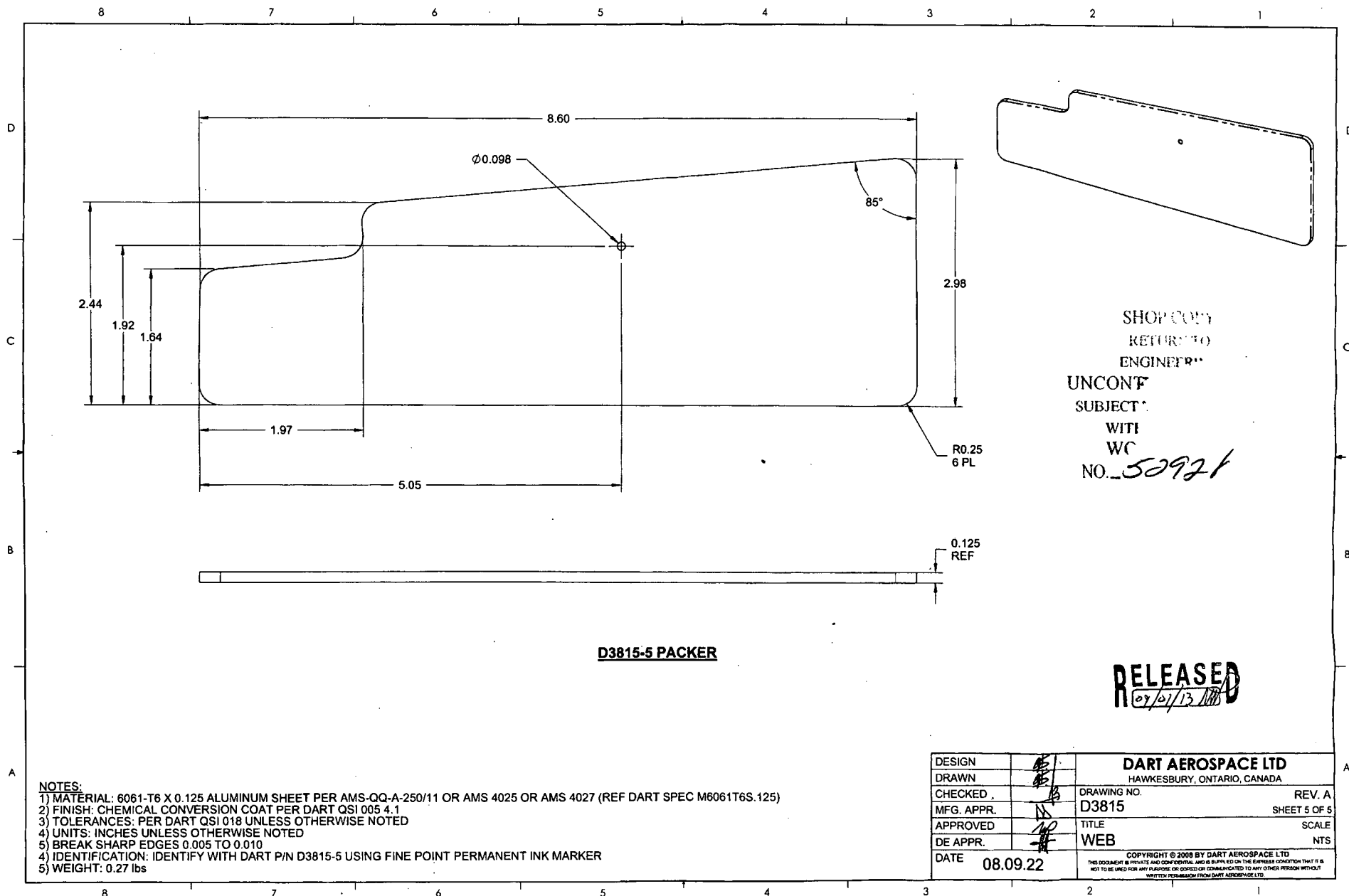
D3815-3 WEB

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09/01/13

NOTES:

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: N/A
- 5) WEIGHT: 0.28 lbs

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NOTES:

- 1) MATERIAL: 6061-T6 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-5 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.27 lbs

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